

Work Order ID 69334-1

Monday, May 09, 2011 10:25:02 AM



Page 1

Item ID: D350-689-023

Accept



Setup Start



Revision ID:

split 2

Item Name: Energy Attenuating Floor Provisions

Stop



Start Date: 5/9/2011 Start Qty: 2.00

Required Date: 5/13/2011 Req'd Qty: 2.00

36



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-05-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI D9419

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-689-023 CHG001

8/11/05/11

Order CL 11-5-10

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/11 SP (2x)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/11/05/11

(42)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69334

Monday, May 09, 2011 10:25:02 AM



Page 2

Item ID: D350-689-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Energy Attenuating Floor Provisions

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-689-023

Location:

PPP Rev:

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/5/11 S/P (24)

11/5/11

MF
11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

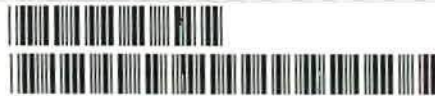
Monday, May 09, 2011 10:24:58 AM

Page 1

Work Order ID: 69334

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions



Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by:EC
route seq DD 10.02.12 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S ₂ AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	9	18.27		11/5/11	M116583
S ₂ D3025-1 Beam		Manufactured	No			110	Each	2.0000	1				
					<u>Location</u> ST177				<u>Loc Qty</u> 2	<u>Loc Code</u>			
					68627				2				
S ₂ D3026-1 Channel		Manufactured	No			110	Each	4.0000	1				
					<u>Location</u> ST177				<u>Loc Qty</u> 4	<u>Loc Code</u>			
					68754				4				
S ₂ D3027-1 Clip		Manufactured	No			110	Each	23.0000	1				
					<u>Location</u> ST031				<u>Loc Qty</u> 23	<u>Loc Code</u>			
					22566				23				
S ₂ D3027-3 Clip		Manufactured	No			110	Each	15.0000	1				
					<u>Location</u> ST031				<u>Loc Qty</u> 15	<u>Loc Code</u>			
					22566				15				

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 69334

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 2.00

Required Qty: 2.00

Sz
D3027-5
Clip

Manufactured No 110 Each 19.0000

1 2
3

Location Loc Qty Loc Code

ST031 19

22566 19

Manufactured No 110 Each 20.0000

4 8
3

Location Loc Qty Loc Code

ST031 20

68755 20

Manufactured No 110 Each 6.0000

1 2
12

Location Loc Qty Loc Code

ST233 6

44165 6

Manufactured No 110 Each 7.0000

1 2
3

Location Loc Qty Loc Code

ST233 7

44166 7

Manufactured No 110 Each 2.0000

1 2
3

Location Loc Qty Loc Code

ST263 2

44697 2

2

Sz
D3811-041
Seat Track Assembly

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 10:24:59 AM

Page 3

Work Order ID: 69334

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 2.00

Required Qty: 2.00

MS20426AD4-5

Purchased

No

110

Each

5,824.000

14

28



Rivet

Location

Loc Qty

Loc Code

MEZZ

535

6733

535

ST317

5289

6874

5289

110

Each

1,533.000

34

68

MS20470AD4-5

Purchased

No



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1533

116410

14

116893

1519

110

Each

2,647.000

18

36

MS20470AD4-6

Purchased

No



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2647

117395

2647

110

Each

1,564.000

32

64

MS20470AD5-6

Purchased

No



Rivet

Location

Loc Qty

Loc Code

ST320

1564

105433

1564

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 69334

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

2,400.000

9

18



Nut

Location

Loc Qty

Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

MS24694-S50

Purchased

No

110

Each

112.0000

9

18



Screw

Location

Loc Qty

Loc Code

ST289

12

116304

12

ST298

100

116900

100

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND FLIGHT MANUAL SUPPLEMENT FMS-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

PURPOSE

The purpose of this DSI is to add the D350-689-021 Dual High Back Seat Installation, LH, the D350-689-023 Floor Provisions Kit and the D350-689-043 Dual High Back Seat Assembly to IIN-D350-689 Rev. A. The D350-689-021/-023 Kits are compatible with the Energy Attenuating Seat rails in later AS 350/355 model aircraft.

The DSI 9419-011 Kit includes the parts that are required to convert a D350-689-011 installation into a D350-689-021 installation.

REFERENCE ONLY

PART LIST

-011	-021	-023	-043	P/N	DESCRIPTION
X				DSI 9419-011	ENERGY ATTENUATING CONVERSION KIT
	X			D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
	1	X		D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
	1		X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
			2	D3016-041	SEAT FRAME ASSEMBLY
			1	D3017-041	BACK FRAME ASSEMBLY
	1			D3018-1	SEAT CUSHION
	1			D3019-1	BACK CUSHION
			1	D3021-041	TUBE ASSEMBLY
			1	D3022-1	SEAT PAN
			1	D3023-1	BACK PANEL
			3	D3024-1	SPACER
		1		D3025-1	BEAM
		1		D3026-1	CHANNEL
		1		D3027-1	CLIP
		1		D3027-3	CLIP
		1		D3027-5	CLIP
		4		D3027-7	CLIP
			2	D3031-1	LOOP
1		1		D3234-1	DOUBLER
1		1		D3234-3	DOUBLER
2			2	D3808-041	SEAT RAIL ASSEMBLY
4			4	D3809-1	SLIDING BLOCK
1		1		D3811-041	SEAT TRACK ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: Aug. 19/2008
CERT. NO.: SH02-33
ISSUE NO.: 1

A	NEW ISSUE	RF	08.08.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	ENERGY ATTENUATING PROVISION KIT	NTS
DATE	08.08.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

REFERENCE ONLY

-011	-021	-023	-043	P/N	DESCRIPTION
			3	AN3-12A	BOLT
14		14		MS20426AD4-5	RIVET
34		34		MS20470AD4-5	RIVET
18		18		MS20470AD4-6	RIVET
		32		MS20470AD5-6	RIVET
			40	MS20600AD4W2	RIVET
			6	MS20600AD4W3	RIVET
9		9	23	MS21042L3	NUT (or MS21042-3)
			4	MS24693-S272	SCREW
8			8	MS24694-S3	SCREW
9		9		MS24694-S50	SCREW
4			4	MS24694-S148	SCREW
			4	MS27039-1-17	SCREW
			12	MS27039-1-19	SCREW
			23	NAS1149D0332J	WASHER (or AN960JD10L)
9		9		NAS1149D0363J	WASHER (or AN960JD10)

PROCEDURE

1. Install the under floor structure as outlined in steps 1-18 of IIN-D350-689 Rev. A and DSI 9311 Rev. A as applicable, except do not install D3032-1 Spacers. Attach D3026-1 Channel to floor using (14) MS20426AD4 rivets. Ensure D3234-1/-3 Doublers are installed per DSI 9269 Rev. A.
2. Position the D3811-041 Seat Track Assy at LBL 27.33 as shown in Figure 1 to be in-line with the existing seat rails at LBL 8.98 and LBL 19.16.
3. Transfer the attachment holes from D3811-041 Seat Track Assy to aircraft floor (9 pls) using a $\phi 0.201$ (#7 drill). Deburr holes. Install D3811-041 using (9) MS24694-S50 screws, (9) NAS1149D0363J washers, and (9) MS21042L3 nuts as shown in Figure 1. Torque screws to 20 to 25 in-lbs (2.3 to 2.8 Nm).
4. If converting a -041 Seat Assembly to a -043 Seat Assembly, remove D3028-1 Studs, D3029-1 Springs, and D3030-1 Locks from the D350-689-041 Seat Assembly. Install (2) D3808-041 Seat Rails Assemblies as shown in Figure 1 Detail A using (4) MS24694-S148 Screws. Torque screws to 100 to 140 in-lbs (11.3 to 15.8 Nm). Install D3809-1 Sliding Blocks using (2) MS24694-S3 screws as shown in Figure 1 Detail A. Torque screws to 12 to 15 in-lbs (1.4 to 1.7 Nm).
5. Remove screws from back end of Seat Tracks at LBL 27.33 and LBL 8.98. Slide D350-689-043 Seat Assembly into both seat tracks and lock in desired position using D3810-1 Retractable Spring Plungers. Re-install screws on back of seat tracks per the Aircraft Maintenance Manual.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: Aug. 19/2008
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 2 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	ENERGY ATTENUATING PROVISION KIT	NTS
DATE	08.08.19	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	